

Date: Monday, 27/04/2009 12:51:04 PM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : GASKET |
| Job Number : 47526 | |
| Estimate Number : 12719 | |
| P.O. Number : | Part Number : D353625 |
| This Issue : 27/04/2009 S.O. No. : | Drawing Number : D3536 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL / MED FAB | Drawing Revision : A |
| Previous Run : 47011 | Material : |
| Written By : | Due Date : 07/05/2009 Qty: 20 Um: Each |
| Checked & Approved By : <u>JWD 09.04.27</u> | |
| Comment : Est Rev:A New Issue 07-02-14 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------|----------------------|
| 1.0 | MNEO60S063 | NEOPRENE SHEET 0.063 |
|-----|------------|----------------------|



Comment: Qty.: 0.6863 sf(s)/Unit Total : 13.7268 sf(s)
 NEOPRENE SHEET 0.063 **HB 9-4-30**
 Batch: 111015

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3536
 Dwg Rev: A **HB 9-4-30**
 Prog Rev: A
 2-Deburr if necessary



| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

508/04/30 **count**
(20)

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

Finishing Dept.

8809/05/01 (20)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:51:04 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 47526

Part Number: D353625

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04 JF

Job Completion



MF
09-05-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|------------------------------|
| DART AEROSPACE LTD | | Work Order: 47524 |
| Description: Gasket | | Part Number: D3536-25 |
| Inspection Dwg: D3536 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 21.80 | +/-0.030 | 21.86 | X | | | |
| 16.35 | +/-0.030 | 16.35 | X | | | |
| 10.90 | +/-0.030 | 10.96 | X | | | |
| 5.45 | +/-0.030 | 5.45 | X | | | |
| 6.00 | +/-0.030 | 6.00 | X | | | |
| 6.75 | +/-0.030 | 6.75 | X | | | |
| 12.75 | +/-0.030 | 12.75 | X | | | |
| 1.89 | +/-0.030 | 1.900 | X | | | |
| 0.30 | +/-0.030 | .305 | X | | | |
| 0.30 | +/-0.030 | .304 | X | | | |
| Ø0.19 | +0.005/-0.001 | .190 | X | | | |
| | | | | | | |
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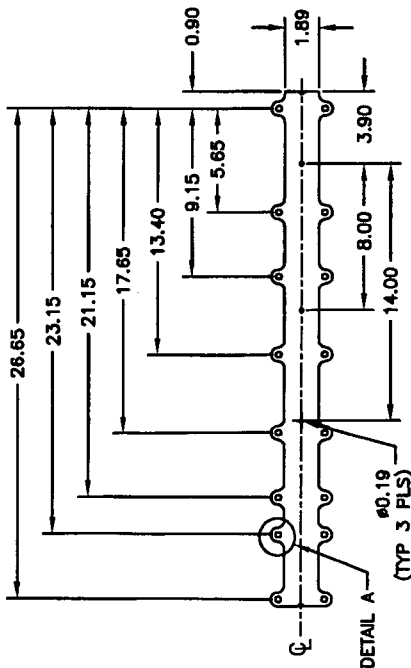
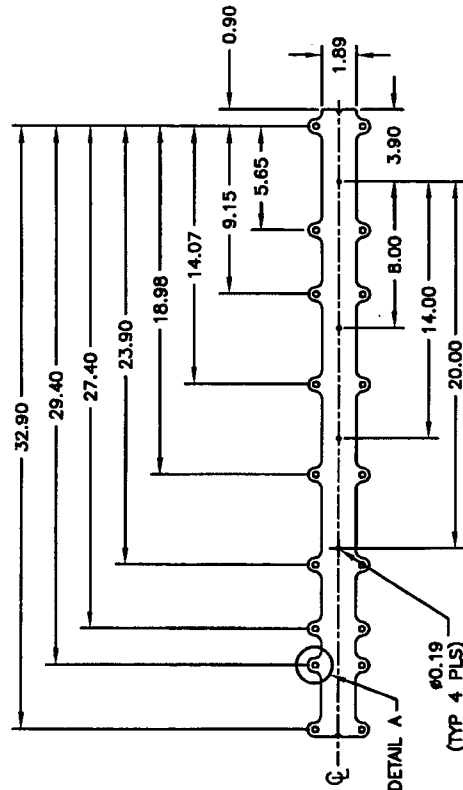
| | | | |
|------------------------|-----------------------|----------------------------|-----|
| Measured by: RB | Audited by: S | Prototype Approval: | N/A |
| Date: 9-4-30 | Date: 09/04/30 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.06.13 | New Issue | KJ/JLM | EB |

DART

| | | | |
|-------------------------|--------------------------------|---|------------------------|
| DESIGN CB | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED <i>[Signature]</i> | DRAWING NO. D3536 | REV. A SHEET 1 OF 6 |
| DATE 06.10.25 | | TITLE GASKET | SCALE 1:10 |
| A | 06.10.25 | NEW ISSUE | |

RELEASED

09.02.12 *[Signature]***D3536-11 GASKET****D3536-13 GASKET**

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *15216*

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

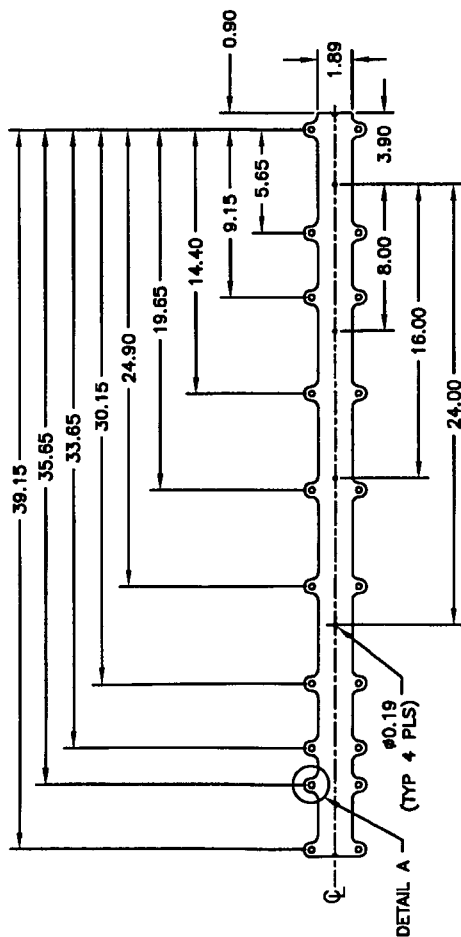
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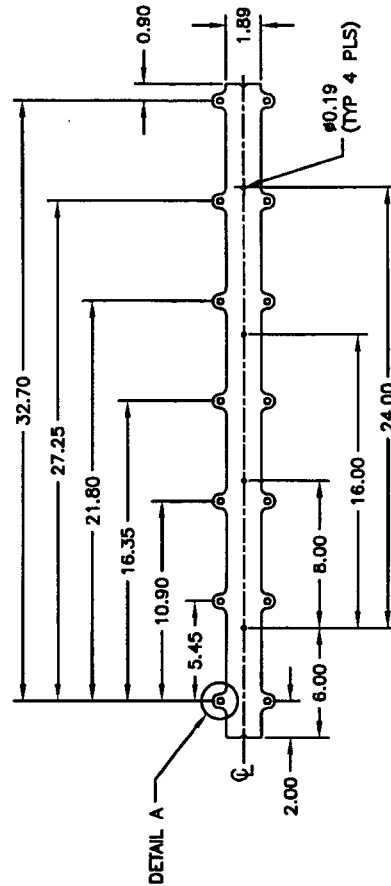
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| DATE 06.10.25 | TITLE GASKET | | SCALE 1:10 |

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**D3536-15 GASKET**

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**D3536-21 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NEO80-S.083)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

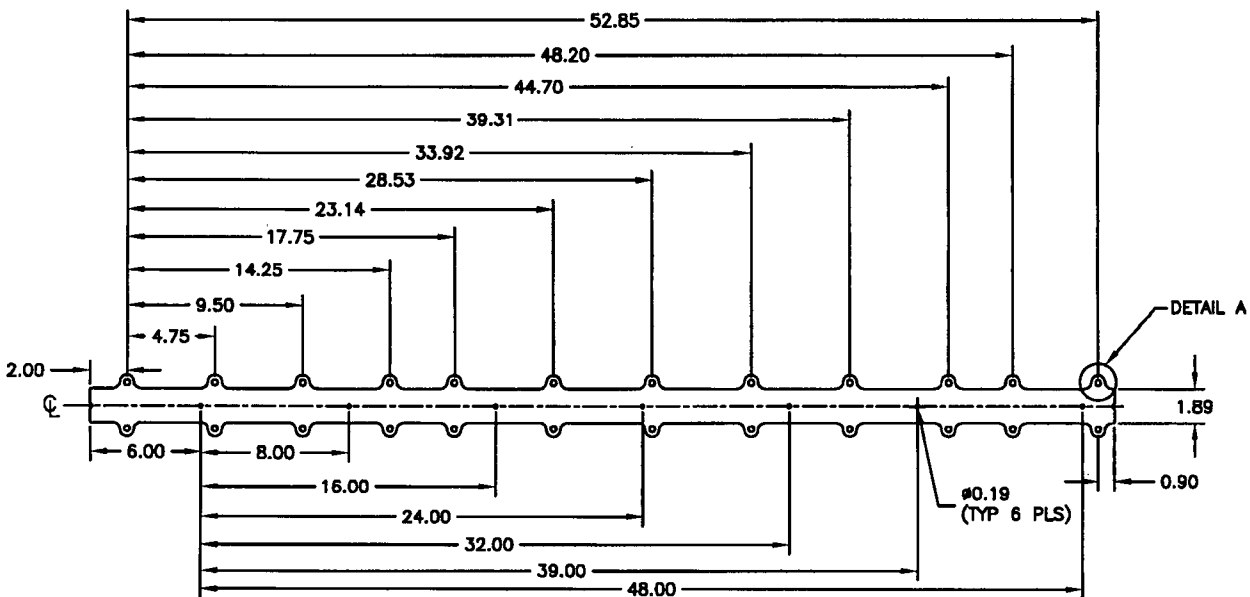
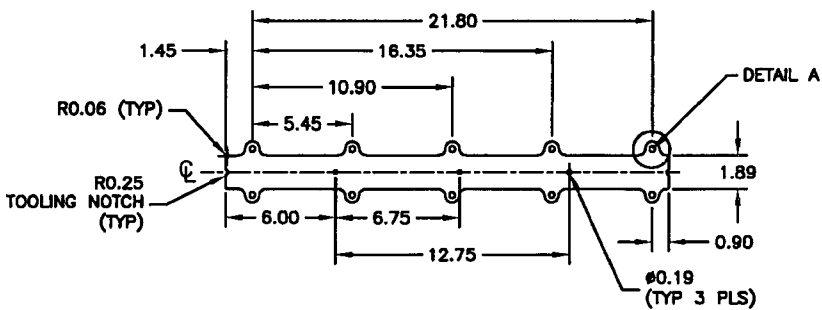
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| DATE 06.10.25 | | TITLE | GASKET | SHEET 3 OF 6 |
| | | | | SCALE 1:10 |

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**D3536-23 GASKET****D3536-25 GASKET**

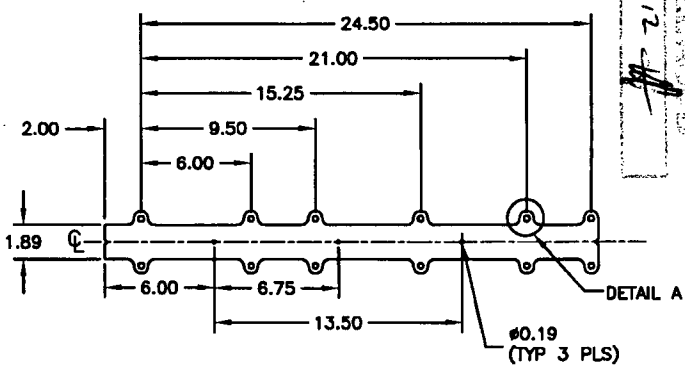
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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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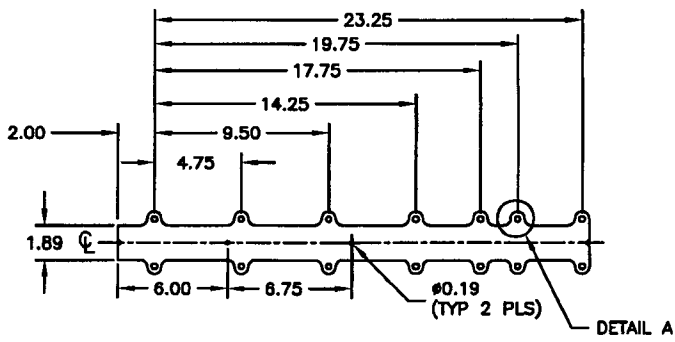
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| DATE | 06.10.25 | DRAWING NO. | D3536 | REV. A |
| | | TITLE | GASKET | SHEET 4 OF 6 |
| | | SCALE | 1:10 | |

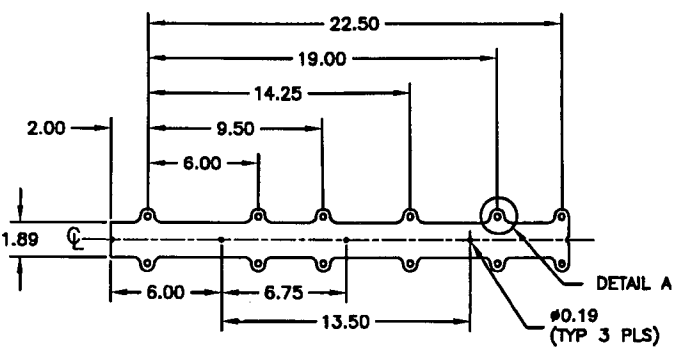
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

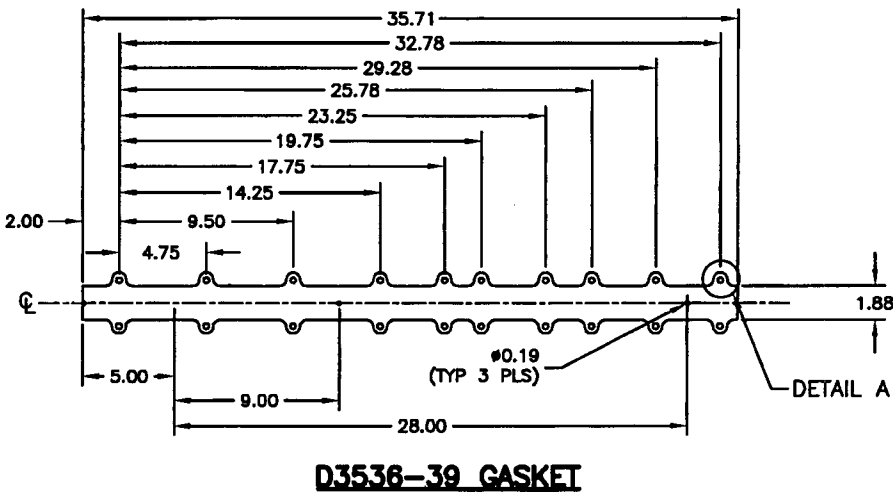
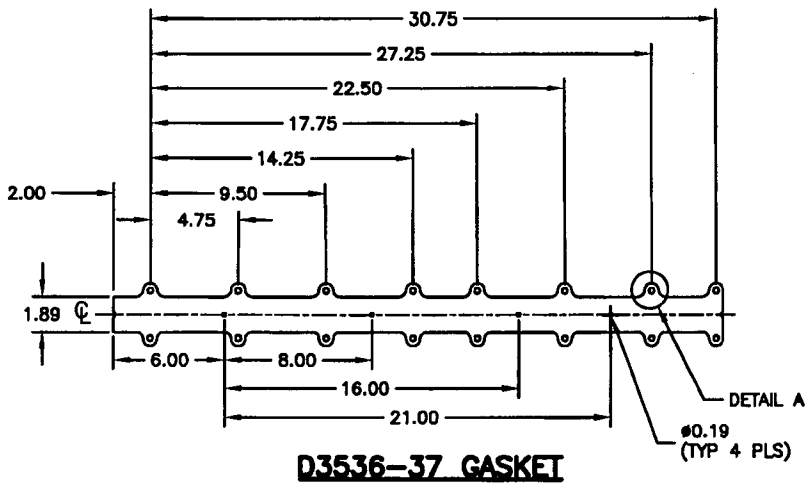
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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| DATE 06.10.25 | | TITLE GASKET | REV. A |
| | | | SHEET 5 OF 6 |
| | | | SCALE 1:10 |

07.02.02 **CH**



NOTES

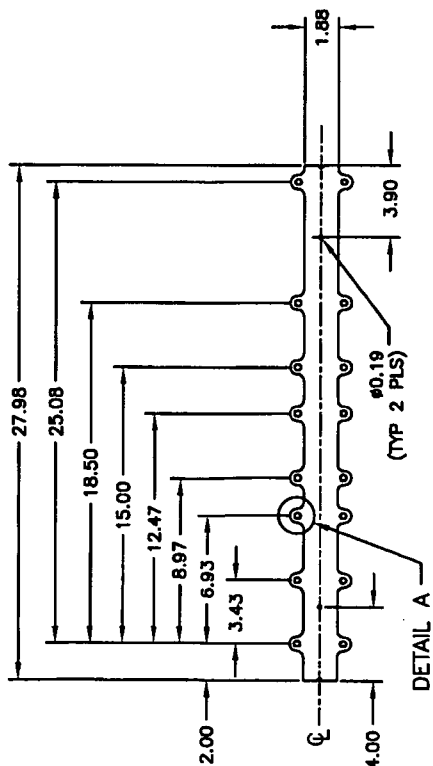
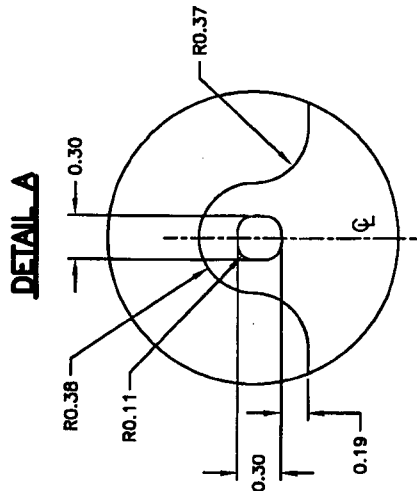
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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| DATE 06.10.25 | TITLE GASKET | | SCALE 1:10 |

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07.02.12 **[Signature]**



D3536-41 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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